



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2572
Job Sheet 173724



Part No: D2572

Job Qty: 10 ea

Part Name: Saddle, Fwd, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		3/29/18	0.00	0.00	Start Up Machining		SBL 18/03/31
100	CNC Vertical Machining	10 pcs		3/29/18	0.62	16.13	HAAS 1		SBL 18/04/05
110	Mill Conv	10 pcs		3/29/18	0.00	1.67	Mill Conv 1		SBL 18/04/05
120	QC	10 pcs		3/29/18	0.00	0.00	QC2		SBL 18/04/05
130	QC	10 pcs		3/29/18	0.00	0.00	QC8		SBL 18/04/05
140	HandFinish	10 pcs		3/29/18	0.00	0.41	HandFinish1		SBL 18/04/05
150	Powdercoat	10 pcs		3/30/18	0.00	0.38	Powdercoat1		SBL 18/04/05
160	QC	10 pcs		3/30/18	0.00	0.00	QC3		SBL 18/04/05
170	Packaging	10 pcs		3/30/18	0.00	0.00	Packaging3		SBL 18/04/05
180	QC21-SA	10 Ea		3/30/18	0.00	0.00	QC21		SBL 18/04/05

Part Op 100 - Program Batch No. Double check by: 1-Machine Step No 1 per Folio FA051 and inspect per

Descriptions: attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp

110 - Machine keyway as per dwg D2571 & D2572

150 - START TIME: 8:35 FINISH TIME: 4:05. OV. T: 300 M 138760.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-005	10	29	0

5038651 -> 5057097

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438	
2	Saddle, Fwd Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
3	Saddle, Fwd Inboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495	
4	Saddle, Fwd Inboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition
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Dart Aerospace Ltd.
 1270 Aberdeen Street
 Newbury, ON K8A 1K7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaero.com

Date: 03/31/18

Root Cause							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐				
Design ☐	☐	Operator ☐	Bending ☐				
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐				
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐				
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐				
Material ☐	☐	Use for Testing ☐	Cuffs ☐				
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐				
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐				
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐				
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐				
Past Expiry Date ☐	☐	Manufacturing Process ☐					
Misidentified ☐	☐	Past Due ☐					
			OTHER :				



Container No: S057098
 Part: D2572
 Job No: 173724
 Serial No/Batch: S057098
 Revision:
 Inspector:

☐ Countersink	☐ Misaligned/off center	☐ Finish
☐ Cut Too Short	☐ Fit/Function	☐ Misread
☐ Instructions Incomplete/Unclear	☐ Turning Sequence	
☐ Drill Holes		

5	Saddle, Fwd Inboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Fwd Inboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Fwd Inboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Fwd Inboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Fwd Inboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Fwd Inboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Fwd Inboard	1.490Inches	+ 0.010 - 0.000	1.500 1.490
14	Saddle, Fwd Inboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Fwd Inboard	3.869Inches	+ 0.010 - 0.000	3.879 3.869
16	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART AEROSPACE LTD	Work Order: 173 724
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 3

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	0.438		
B	1.745	1.755		.750	.749	.750	.750		
C	3.495	3.505		3.500	3.501	3.500	3.500		
D	1.745	1.755		.750	.749	.750	.750		
E	7.990	8.010		8.000	8.000	8.001	8.001		
F	0.490	0.510		.497	.498	.500	0.503		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.498	.500	.498	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.566	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.875	3.875	3.875		
P	0.115	0.135		.133	.130	.130	.130		
Q	0.115	0.135		.123	.122	.125	.125		
R	0.240	0.260		.251	.252	.252	.252		
S	0.115	0.135		.125	.126	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.960	2.962	2.961		
V	0.230	0.250		.241	.240	.238	.238		
W	0.115	0.135		.128	.127	.130	.132		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.362	.362	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.069	.066	.069	.066		
AD	0.240	0.260		.250	.250	.248	.251		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.130	.130	.128	.129		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.249	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	0.033		

Accept/Reject

Measured by: SBL
Date: 18/03/31

Audited by: [Signature]
Date: 18/04/07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 173724
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 1 of 3

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 1	6 2	7 3	8 4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.745	1.745	1.75		
C	3.495	3.505		3.495	3.495	3.5	3.5		
D	1.745	1.755		1.745	1.750	1.75	1.75		
E	7.990	8.010		8.002	8.002	8.001	8.002		
F	0.490	0.510		0.500	0.499	0.5015	0.501		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.499	0.4975	0.4985	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.564	0.565	0.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.5		
O	3.869	3.879		3.873	3.875	3.874	3.874		
P	0.115	0.135		0.130	0.129	0.125	0.132		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.125	0.124	0.125	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.238	0.241	0.240		
W	0.115	0.135		0.127	0.124	0.128	0.124		
X	0.307	0.312		0.311	0.312	0.310	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.363	0.363		
AA	0.470	0.530		0.506	0.500	0.50	0.50		
AB	0.615	0.635		0.625	0.624	0.625	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.250	0.249	0.251		
AE	1.375	1.395		1.375	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.135	0.129	0.132		
AG	0.240	0.280		0.250	0.250	0.250	0.25		
AH	0.240	0.260		0.250	0.251	0.251	0.25		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: SBC
Date: 18/04/01

Audited by: [Signature]
Date: 18/04/07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 173274 173274
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. F	Page 3 of 3

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	19	210	3	4		
A	0.438	0.443		0.438	0.438				
B	1.745	1.755		1.740	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.001				
F	0.490	0.510		0.500	0.500				
G	0.257	0.262		0.257	0.257				
H	0.375	0.380		0.375	0.375				
I	0.490	0.510		0.498	0.498				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.566	0.566				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.499	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.875	3.875				
P	0.115	0.135		0.130	0.130				
Q	0.115	0.135		0.125	0.125				
R	0.240	0.260		0.252	0.252				
S	0.115	0.135		0.125	0.125				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.240	0.240				
W	0.115	0.135		0.125	0.125				
X	0.307	0.312		0.311	0.311				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.361	0.362				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.625	0.625				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.251	0.251				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		0.125	0.125				
AG	0.240	0.280		0.250	0.250				
AH	0.240	0.260		0.250	0.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by: SBL	Audited by: [Signature]
Date: 18/04/05	Date: 18/04/07

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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F	13.03.07	Dwg Rev updated	KJ	